

Work Order ID 98098

Tuesday, March 05, 2013 3:39:55 PM

98098Ship today
Page 1
AOG

Item ID: D350-567-141

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Window Closeout Installation

Start Date: 3/5/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/5/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

MMF

Date:

13-3-5

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9590

C

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-567-141 CHG002

DAS
16
13/3/5

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

8 13/3/5

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
16
13/3/5

⑦

Work Order ID 98098***98098***

Page 2

Tuesday, March 05, 2013 3:39:55 PM

Item ID: D350-567-141

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Window Closeout Installation

Start Date: 3/5/2013 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/5/2013 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D350-567-141
Location: _____*ship via 13-3-5*

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13/3/5
unc 13-3-5

Tuesday, March 05, 2013 3:39:53 PM

Page 1

Required Qty: 1.00

Comments: IPP REV:A 11.11.09 new issue DD VERF:JLM IPP REV:B 12.01.23 AS PER
ECN12-511 DD VERF:EC IPP REV:C 12.03.05 AS PER ECN12-537 DD VERF:EC

Status

Fwd Bracket Assembly

● Cover Assembly

T/R Bellcrank Cover Assembly

2

Picklist Print

Tuesday, March 05, 2013 3:39:54 PM

Page 2

Work Order ID: 98098

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 3/5/2013

Required Date: 3/5/2013

Start Qty: 1.00

Required Qty: 1.00

D4435-9
Bracket

Manufactured No

110 Each 16.0000

2 2

5/1

Location

Loc Qty

Loc Code

ST110

6

94718

6

ST273

10

96444

10

2

D4436-041
Aft Bracket Assembly

Manufactured No

110 Each 1.0000

0 1

5/1

Location

Loc Qty

Loc Code

ST272

1

95817

1

1

D4441-1
Rubber Seal

Manufactured No

110 f 449.2146

2 2

5/1

(D4441-1-240) GUT (1) AT 24.00" PER KIT

Location

Loc Qty

Loc Code

ST412

449.2146

74760

6.119

79385

0.0476

80763

35.656

86185

407.392

2

AN3-3A
Bolt

Purchased No

110 Each 435.0000

7 7

5/1

Location

Loc Qty

Loc Code

ST350

435

123831

135

124221

200

124552

100

Tuesday, March 05, 2013 3:39:54 PM

Shop Packet Print

Page 2

Picklist Print

Tuesday, March 05, 2013 3:39:54 PM

Page 3

Work Order ID: 98098

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 3/5/2013

Required Date: 3/5/2013

Start Qty: 1.00

Required Qty: 1.00

AN525832R7

Screw

Purchased

No

110

Each

302.0000

2

3/5

Location

Loc Qty

Loc Code

GA

34

120519

34

ST343

268

120560

268

Purchased

No

110

Each

39.0000

7

2/5

Location

Loc Qty

Loc Code

ST314

39

122441

3

123900

36

Purchased

No

110

Each

4,057.0000

2

2/5

Location

Loc Qty

Loc Code

ST315

4057

122141

3

122452

9

122814

500

123900

3545

2

MS21042L08

Nut

Tuesday, March 05, 2013 3:39:54 PM

Shop Packet Print

Page 3

Picklist Print

Tuesday, March 05, 2013 3:39:54 PM

Page 4

Work Order ID: 98098

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 3/5/2013

Required Date: 3/5/2013

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Nut

Purchased

No

110

Each

6,644.0000

5

5

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

278

122452

278

ST314

268

117885

32

119017

55

119075

138

123265

43

ST506

6095

123900

2095

124291

4000

MS21059L3

Nut Plate

Purchased

No

110

Each

301.0000

2

2

Location

Loc Qty

Loc Code

ST316

101

124291

101

ST506

200

124308

200

MS35206-229

Screw

Purchased

No

110

Each

145.0000

7

7

Location

Loc Qty

Loc Code

ST288

145

121039

45

123832

100

Tuesday, March 05, 2013 3:39:55 PM

Shop Packet Print

Page 4

Picklist Print

Tuesday, March 05, 2013 3:39:55 PM

Page 5

Work Order ID: 98098

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 3/5/2013

Required Date: 3/5/2013

Start Qty: 1.00

Required Qty: 1.00

8 ~~NAST1049F0332P~~
WASHER

Purchased

No

110

Each

10,520.000

~~12~~

12

sd

Location

Loc Qty

Loc Code

GA

194

122063

194

ST294

323

122063

323

ST295

3

123352

3

st510

10000

123900

10000

12x

8 ~~NAST1149FN616P~~
WASHER

Purchased

No

110

Each

301.0000

~~14~~

14

sd

Location

Loc Qty

Loc Code

ST294

301

120560

301

Each

685.0000

14x

2

sd

8 ~~NAST1149FN816P~~
WASHER

Purchased

No

Location

Loc Qty

Loc Code

ST294

685

117316

215

121039

470

2x

Tuesday, March 05, 2013 3:39:55 PM

Shop Packet Print

Page 5

REFERENCE ONLY

2.0 Part List

Qty -141	Part Number	Description
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L37	NUT (OR MS21042-3)
2	MS21059U3	NUTPLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 — OK to remove D3295-041
 - D350-567-031 — OK to remove D3212-1
 - D350-567-011 — OK to remove D2214
 - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.03.13
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	12.03.13	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	